

Work Order ID 67565

Monday, March 28, 2011 11:07:55 AM



Ship 1st week April

Page 1

Item ID: D4038-3	Accept		Setup	Start	
Revision ID:					
Item Name: Angle, Aft, LH				Stop	
Start Date: 3/28/2011	Start Qty: 3.00				
Required Date: 4/5/2011	Req'd Qty: 3.00				
Reference:					

Approvals:	Process Plan: <u>umf</u>	Date: <u>11-03-28</u>	Tooling:	Date:	Run	Start	
	QC: <u>1</u>	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	D								

100		Bandsaw		0.00					
		Jeaspa Bandsaw		0.00	<i>umf 11/03/29</i>	<u>3</u>	<u>2</u>		
		Memo							
		Cut Blank 7.625" long							

110		HAAS 1		0.00					
		HAAS CNC vertical machine #1		0.00	<i>umf 11/03/30</i>	<u>3</u>	<u>0</u>		
		Memo							
		Mill as per Dwg & Folio FA880							
		Dwg Rev: <u>1</u>							
		Folio Rev: <u>AA</u>							
		Deburr							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67565

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Page 2

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, LH

Start Date: 3/28/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

only 11/03/30

3

~~0~~

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

OK 11/3/30

3

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

3 OK 11-3-30

Hand Finishing

W/O:		WORK ORDER CHANGES						
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Picklist Print

Monday, March 28, 2011 11:07:52 AM

Page 1

Work Order ID: 67565



Parent Item: D4038-3



Parent Item Name: Angle, Aft, LH

Start Date: 3/28/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	0.0000	0.7	2.210526			
6061T6 ANGLE 4.00 x 4.00 x .250													

M 114507

2.21"

enl 11/03/29

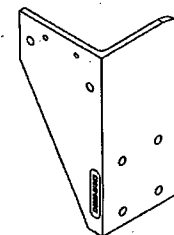
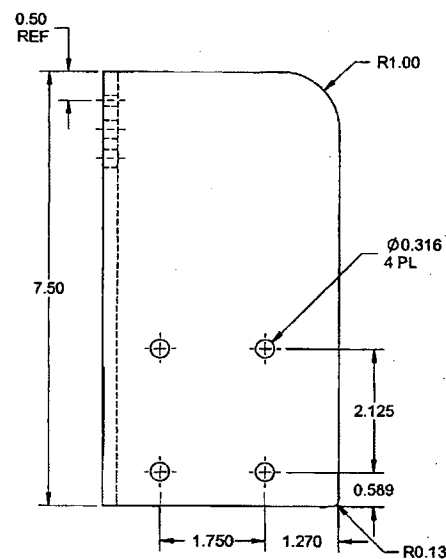
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NOTE: Date & initial all entries



X 67505

RELEASED
2011-03-17

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.19 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

D4038-3 ANGLE, AFT, LH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D4038	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.03.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISCLOSURE TO ANY OTHER PERSON OR ENTITY IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY	

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